


Date: Tuesday, 05/09/2006 10:35:36 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BAFFLE ASSEMBLY
Job Number :	28409		
Estimate Number :	11264		
P.O. Number :	N/A	Part Number :	D3276041
This Issue :	05/09/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3276 REV B
First Issue :	01/09/2006	Project Number :	N/A
Previous Run :	26084	Drawing Revision :	B
		Material :	N/A
Written By :		Due Date :	20/09/2006
Checked & Approved By :		Qty:	10
Comment :	Est Rev:A New Issue 05-12-06 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 1.0715 sf(s)/Unit Total: 10.7153 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.040" thick

(M6061T6S.040)

Batch: *1100742 + M19380*

MM 08 09 06

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

MM 08 09 06

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MM 08 09 06

(10)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08 09 06 (10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr *SAD 08 09 10 10*

2-Roll as per Dwg D3276

Date: Tuesday, 05/09/2006 10:35:36 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 28409

Part Number: D3276041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3276, check with template DT8825

SB 06/09/25 10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-09-25 (10)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JL 06/09/28 X 10

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-10-02 (10)
a.m 06/10/12 (1)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 10 02 (10)

11.0

D2464

3/4 Seal



Comment: Qty.: 2.2500 f(s)/Unit Total: 22.5000 f(s)

Pick:

Qty Part Number

Description Batch

27.0" D2464

Neoprene Seal

B28812

FF 06-10-18 10

12.0

D32763

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3276-3

Decal

B 25228 X5 / B 28810 X5

FF 06-10-18 10

Date: Tuesday, 05/09/2006 10:35:36 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 28409

Part Number: D3276041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D3276

FF 06-10-18

10

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206.10.18 (10)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST105

4/10/19 (10)

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/10/20 (10)

Job Completion



U 06.10.19

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BAFFLE ASSEMBLY
Job Number	: 28409		
Estimate Number	: 11264		
P.O. Number	:	Part Number	: D3276041
This Issue	: 9/1/2006 S.O. No. :	Drawing Number	: D3276 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 26084	Material	:
Written By	: _____	Due Date	: 9/20/2006 Qty: 10 Um: Each
Checked & Approved By	: _____		
Comment	: Est Rev:A New Issue 05-12-06 JLM		

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty.: 1.0715 sf(s)/Unit Total : 10.7153 sf(s)
Material: 6061-T6 (QQ-A-250/11) 0.040" thick
(M6061T6S.040)
Batch:

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
Cut blank: 8.975" x 16.375" grain along 8.975"

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA498 and Dwg D3276
Identify as D3276-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:17:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 28409

Part Number: D3276041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Roll as per Dwg D3276

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3276, check with template DT8825

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

D2464

3/4 Seal



Comment: Qty.: 2.2500 f(s)/Unit Total: 22.5000 f(s)

Pick:

Qty Part Number Description Batch

27.0" D2464 Neoprene Seal _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:17:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 28409

Part Number: D3276041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D32763

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3276-3

Decal _____

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3276

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



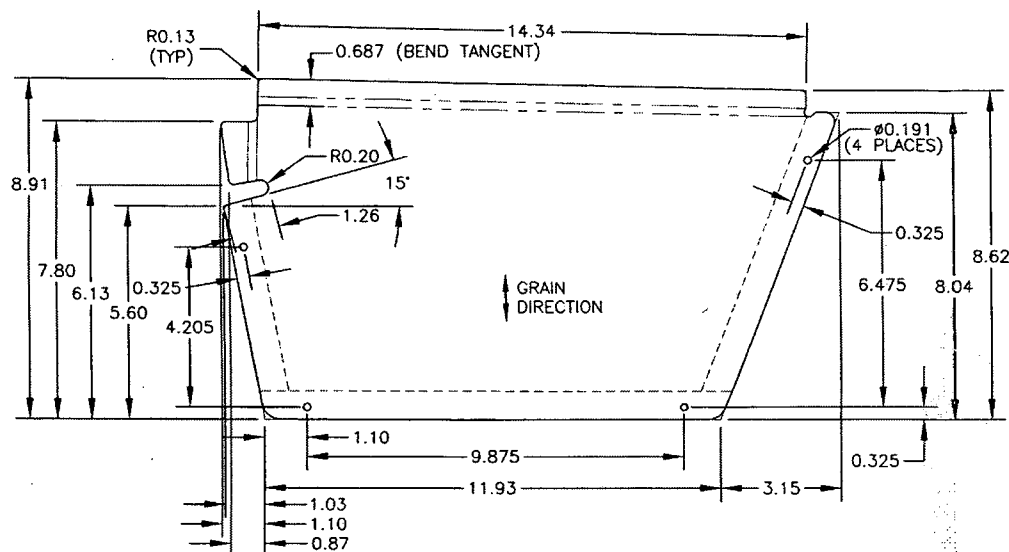
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

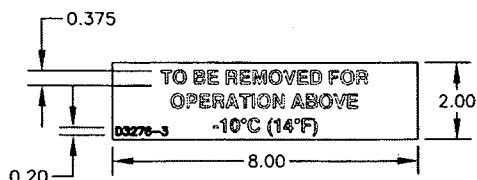
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3276-1 BAFFLE (FLAT PATTERN)

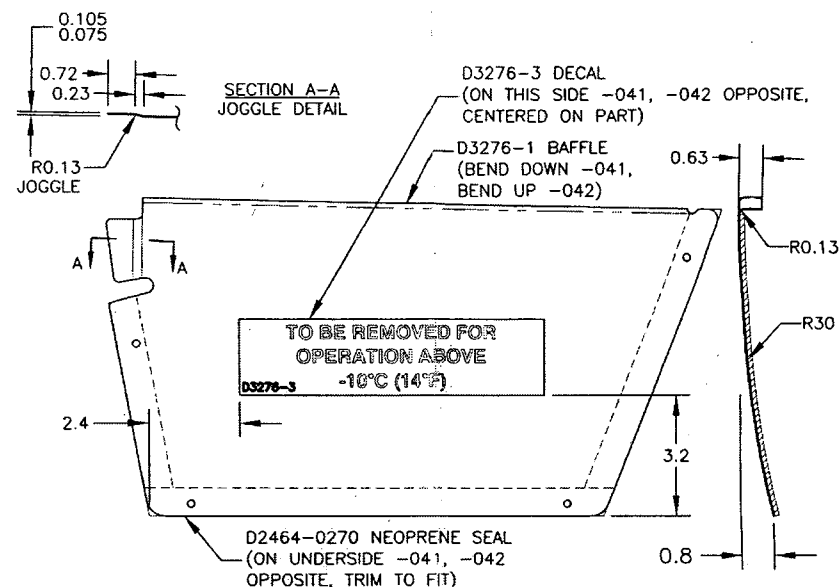
- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 28409
WORK ORDER
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN) D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

RELEASED
05.01.25

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DART AEROSPACE LTD.

B	05.01.25	LABEL NOW -10°C: CURVE PART	
A	05.01.07	NEW ISSUE	
DESIGN	CP	DRAWN BY	CP
CHECKED	✓	APPROVED	✓
DATE	05.01.25	DRAWING NO.	D3276
		TITLE	BAFFLE ASSEMBLY
		REV. B	SHEET 1 OF 1
		SCALE	1:3

DART DART AEROSPACE LTD.
WARRICKSLEY, ONTARIO, CANADA